

Work Order ID 74830

October-11-11 7:06:55 AM

MUST SHIP FRIDAY OCT 14th

74830

Page 1

Item ID: D3510-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube Insert Assembly

Start Date: 10/11/11 Start Qty: 2.00 (1)

2

Cust Item ID:

Required Date: 10/14/11 Req'd Qty: 2.00 (1)

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept
Qty Reject
Qty Reject
Number Insp.
Stamp

Draw Nbr

Revision Nbr

D3510

Rev C

0.00

100

100

MORI SEIKI CNC LATHE LARGE

0.00

Mori Seiki

Memo

Mori Seiki CNC Lathe Large

Turn as per Dwg D3510 & Folio FA652
Ensure that DT8877A Plug fits in tube.

0.00

110

QC2- Inspect parts off machine FAI/FAIB

110

QC

Memo

Quality Control

1 Ø
MML 11/10/11
P/D →
MML 11/10/11

Dart Aerospace Ltd

W/O: 74830		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3510-0-11 PAR #: N/A Fault Category: Landing Gear / Main *Marking* NCR: ☒ Yes ☐ No DQA: *[Signature]* Date: 11.11.10
 Resolution: *Rework* Disposition: *Rework* QA: N/C Closed: *[Signature]* Date: 11/11/10

NCR: 11-959		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11-10-12	H 100	cut the wrong lent H. I cut 30.436 and steel 30.750 <u>R.C. operator error</u> LOA	<i>[Signature]</i> 05/04/13 11/10/13	Return left over part Back in to stock. Qty x1	<i>[Signature]</i> 11/10/13	<i>[Signature]</i> 11/10/13	<i>[Signature]</i> 11/10/13	<i>[Signature]</i> 11/10/13

NOTE: Date & initial all entries

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Page 2

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

1-Machine as per Folio FA652 and Dwg D3510

2-Deburr

Note: *-****.250" dia holes are to opened to finish size by skidtube dept, and missing .266" dia hole is to be drilled by skid dept.*****

130

130

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

140

140

QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

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October-11-11 7:06:55 AM

slip Nov. 2
74830

Page 3

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

150

0.00

150

Skidtubes

0.00

Skidtubes

Memo

1-Drill .266" Dia hole using DT8877B as per Dwg D3510

2-Counter bore wearplate holes as per Dwg d3510.

3-open wearplatre holes to .297 as per Dwg D3510.

4-Deburr

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

170

Chemical Conversion Coat per QSI005 4.1

0.00


170

HandFinish

Memo

0.00

Hand Finishing

> 

11-11-1

 11.11.02 ①

M. L. 11/11/02

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

1 BR 11-11-2.

190

HandFinishing

0.00

190

HandFinish

Memo

0.00

Hand Finishing

Install inserts as per Dwg D3510

1 BR 11-11-2.

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

MA 11-11-02 ①

Dart Aerospace Ltd

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QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

210

Identify as per dwg & Stock Location: _____

0.00

210

Packaging

Memo

PPP 75286

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

Call 11/10 2 (1)

11/11/02

ME 11-11-02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

October-11-11 7:06:55 AM

Page 1

Work Order ID: 74830

Parent Item: D3510-041

Parent Item Name: Skidtube Insert Assembly

Start Date: 10/11/11

Required Date: 10/14/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-10-12 JLM
IPP Rev:B ALES-1032 and ALS4-428 insert now used ECN 1036 DD
IPP Rev:C Revised manufacturing steps for LG 08-09-29 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS4-1032-225

Purchased

No

190

Each

1,852.0000

6

12

Insert

Location

Loc Qty

Loc Code

ST282

1852

118696

110768

62

118386

860

118966

930

6.

BR 11-11-2

ALS4-428-165

Purchased

No

190

Each

489.0000

2

4

Inserts

Location

Loc Qty

Loc Code

FP

471

117769

471

FP-B

18

114172

18

2.

BR 11-11-2

ALS7-1032-130

Purchased

No

190

Each

1,177.0000

2

4

Insert

Location

Loc Qty

Loc Code

ST281

1000

118966

1000

ST282

177

117717

31

118386

146

2.

BR 11-11-2

M6061T6T3.500W.375

Purchased

No

100

f

12.9631

2.55

5.3684211

6061-T6 RD Tube 3.50 X .375 W

Location

Loc Qty

Loc Code

MAT

12

118071

12

MAT014

0.9631

117392

0.9631

5.3684

M.M.L 11/10/11

Dart Aerospace Ltd

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DART AEROSPACE LTD		Work Order: 74830
Description: Skidtube Insert		Part Number: D3510-041
Inspection Dwg: D3510	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.300	+/-0.010	3.301	✓		Vern	cwc-08
Ø2.900	+/-0.010	2.940	✓		"	
Ø2.750	+/-0.010	2.717	✓		"	
R0.25 x 0.066	+/-0.010	0.25 x 0.066	✓			
15.00	+/-0.030	15.00	✓		tape	
0.063 x 45°	+/-0.010 x 0.5°	0.063 x 45°	✓		vern	cwc-08
0.125 x 45°	+/-0.010 x 0.5°	0.125 x 45°	✓		"	
5.270	+/-0.010	5.277	✓		"	
3.265	+0.000/-0.010	3.258	✓		"	
30.50	+/-0.030	30.500	✓		tape	
9.515	+/-0.010	9.515	✓		Vern	CNC-02
6.875	+/-0.010	6.875	✓		"	"
13.750	+/-0.010	13.750	✓		tape	GA-08
1.600	+/-0.010	1.600	✓		H-6	31006
2.165	+/-0.010	2.165	✓		Vern	GA-01
6.735	+/-0.010	N/A 9/11/10-01				
2.981	+/-0.010					
2.434	+/-0.010					
1.036	+/-0.010					
Ø0.266	+0.006/-0.001	Ø0.266	✓		Vern	GA-01
Ø0.391	+/-0.010	Ø0.392	✓		"	"
Ø0.516 x 0.100	+/-0.010	Ø0.520 x 0.100	✓		"	"

Measured by: MAM.C/B.A	Audited by: RP	Prototype Approval:	N/A
Date: 11/10/11	Date: 11.11.1	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.01	New Issue	KJ	

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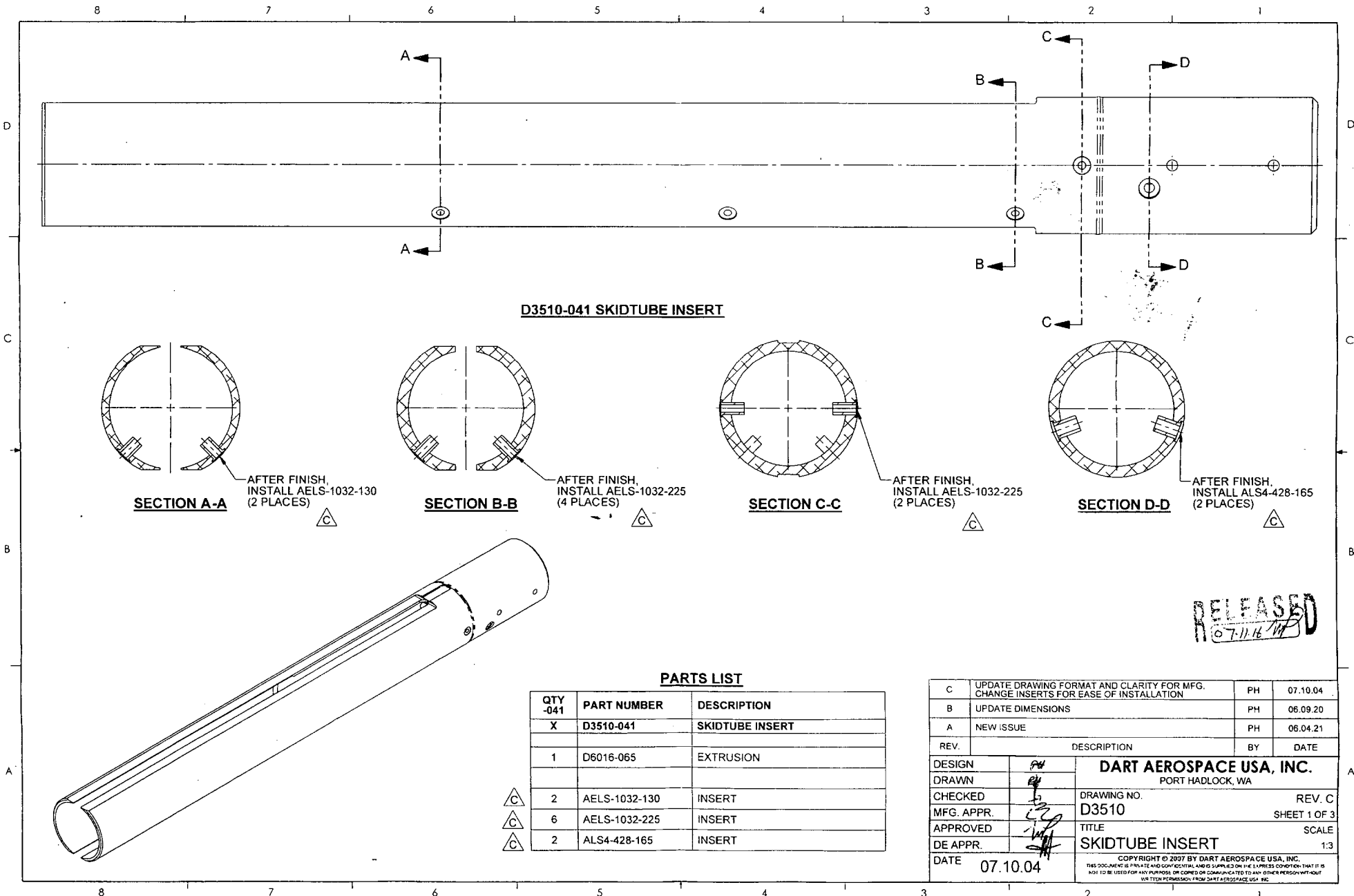
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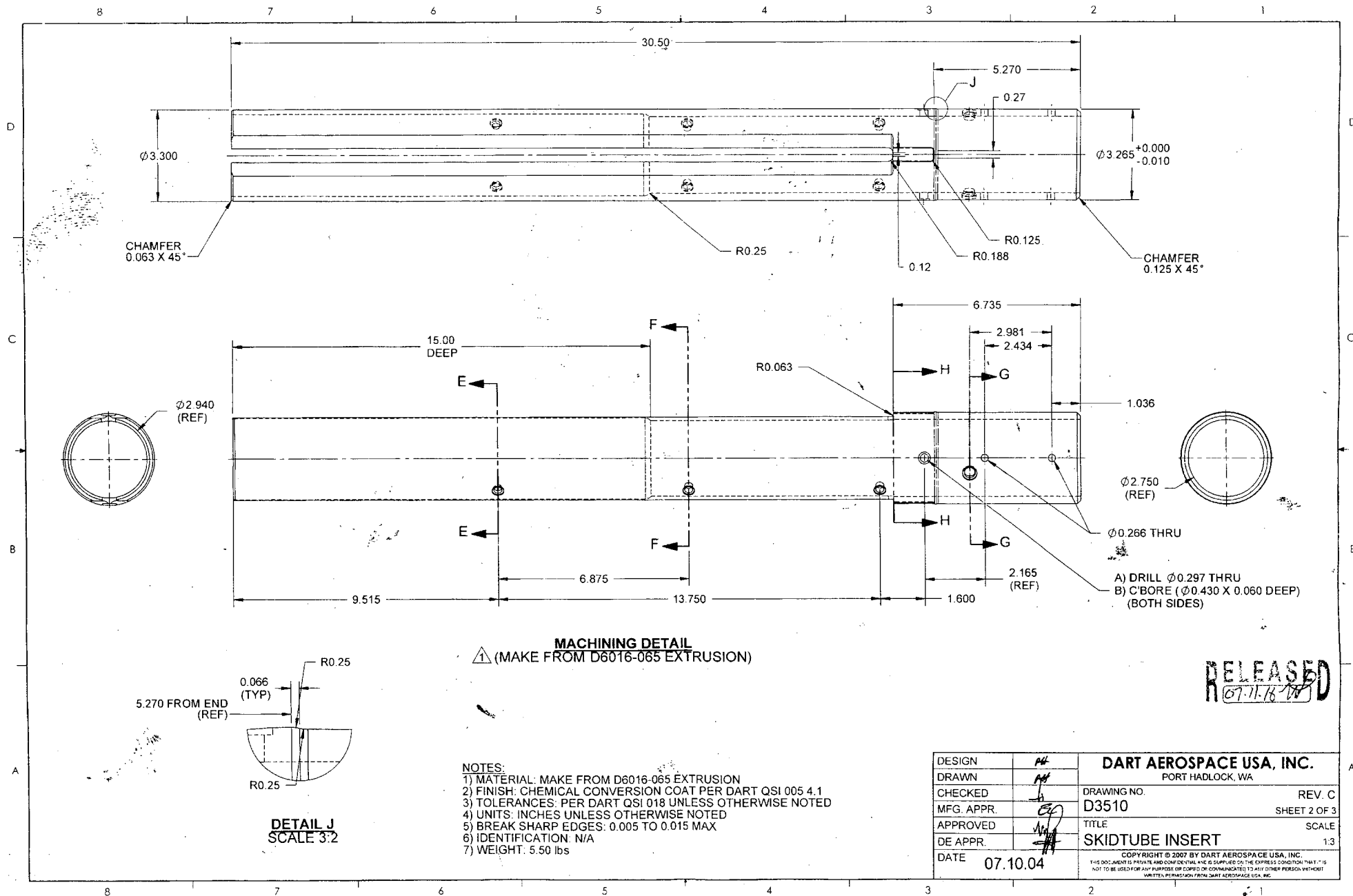
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RELEASED
 07-11-16

125
 123

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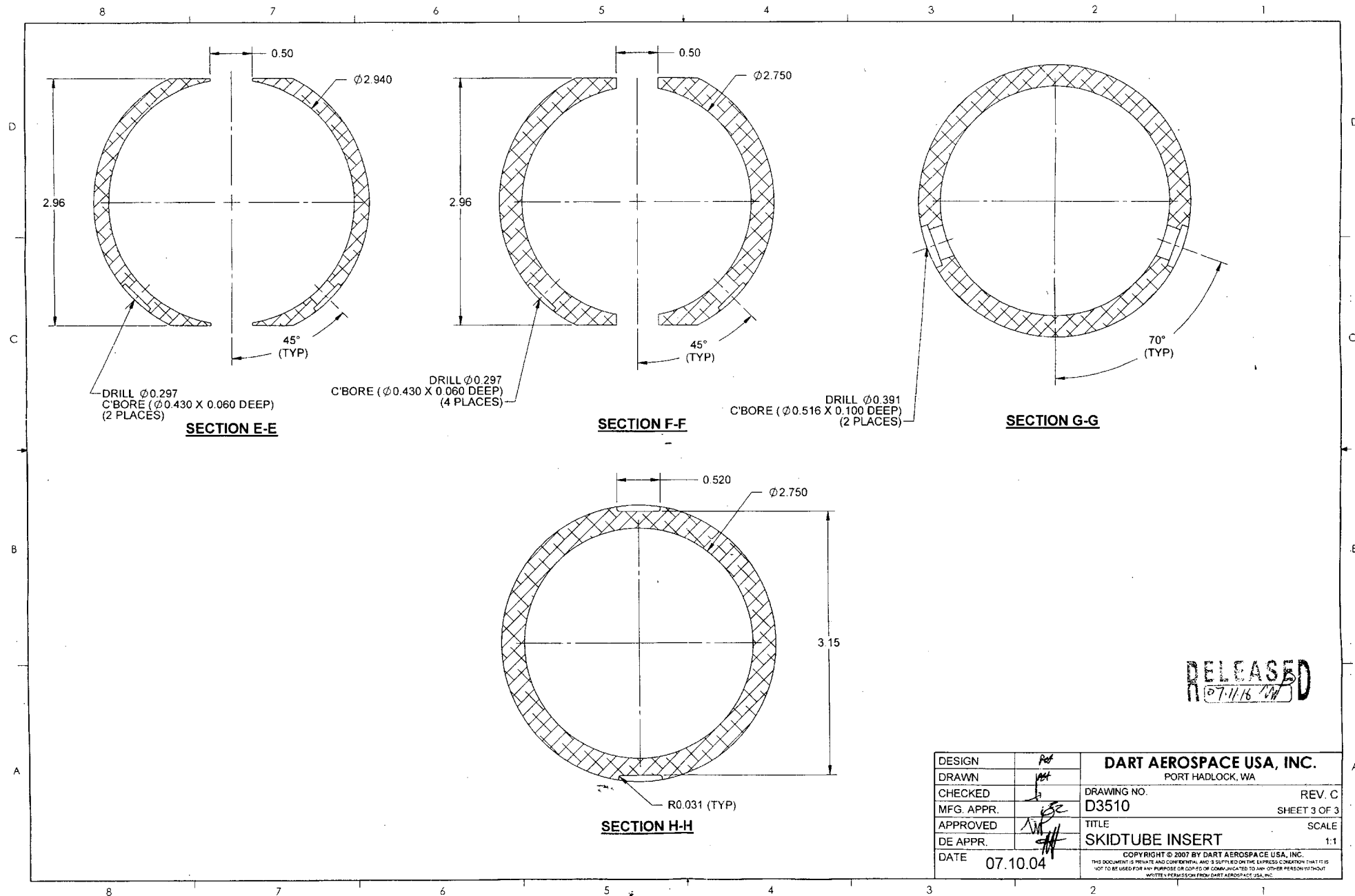
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DESIGN	Ref	DART AEROSPACE USA, INC.	
DRAWN	Ref	PORT HADLOCK, WA	
CHECKED	Ref	DRAWING NO.	REV. C
MFG. APPR.	Ref	D3510	SHEET 3 OF 3
APPROVED	Ref	TITLE	SCALE
DE APPR.	Ref	SKIDTUBE INSERT	1:1
DATE	07.10.04	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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